

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

690 Walnut Ave.St. 150

Vallejo, CA 94592-1133

(707) 649-5453

(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-001597**Date Inspected:** 13-Feb-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Sun Wei & Chen Xi**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

This Quality Assurance Inspector (QAI) observed various fabrication and welding practices at Zhenhua Port Machinery Company (ZPMC) on Changxing Island in Shanghai, China today for the Self Anchored Suspension Bridge for San Francisco, California.

Orthotropic Box Girder (OBG)

In Bay 1 this QAI observed the milling of plate edges, beveling of partial joint penetration (PJP) preparations, machining of 2 millimeter radius on edges of plates and drilling of bolt holes using hardened washer guides of un-bent closed u-rib plates. This QA Inspector also witnessed the simultaneous bending of the close u-rib panels in compliance with the special provisions.

This QAI witnessed ZPMC welders Pan Meng, welder identification 066673 and Liu Xie, welder identification 066236 welding complete joint penetration welds with the shield metal arc welding process (SMAW) on weld joints MUB-MA21 J/J 25 & 26..Some of the essential welding variables were checked and found to be as follows; voltage 22.7 & 23.1, amperage 171 & 174, travel speed 103 & 106 millimeters per minute and preheat 200° Celsius. .

This QAI performed ultrasonic testing (UT) from face 'C' on the complete joint penetration weld between skin plate face B & C from Y locations 0 to 1000 millimeters. For details see ultrasonic testing report TL-6027 dated February 13, 2008.

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Summary of Conversations:

No conversations held today.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By:	Berger,Bruce	Quality Assurance Inspector
Reviewed By:	Cochran,Jim	QA Reviewer
